

Date: Wednesday, 10/09/2008 3:41:19 PM  
 User: Julie Lecocq

## Process Sheet

|                       |                                       |                  |                              |
|-----------------------|---------------------------------------|------------------|------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : CLAMP                      |
| Job Number            | : 41943                               |                  |                              |
| Estimate Number       | : 11285                               |                  |                              |
| P.O. Number           | :                                     | Part Number      | : D34361                     |
| This Issue            | : 10/09/2008 S.O. No. :               | Drawing Number   | : D3436 REV A                |
| Prsht Rev.            | : NC                                  | Project Number   | : N/A                        |
| First Issue           | : / / Type : SMALL /MED FAB           | Drawing Revision | : A                          |
| Previous Run          | : 38193                               | Material         | :                            |
| Written By            | :                                     | Due Date         | : 20/09/2008 Qty: 3 Um: Each |
| Checked & Approved By | : <u>JUL 08.9.10</u>                  |                  |                              |
| Comment               | : Est: A 05.05.10 New issue KJ/JLM    |                  |                              |

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M4130NT2500W063

4130 RD tube 2.50 x .063wall



Comment: Qty.: 0.1531 f(s)/Unit Total : 0.4593 f(s)

4130 tube 2.5"OD.063wall

Cut material : AISI 4130N Steel tubing MIL-T-6736, AMS 6371, 6360,6361,6362,6373 or 6374 to 1.750" as per Dwg D3436

(M4130N-T2500W063)

Identify as D3436-1

Batch: 17679 Dwg Rev. \_\_\_\_\_

SB 08/09/11 (3)

2.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr &amp; Fillet ID 0.030" as per Dwg D3436

SB 08/09/11 (3)

3.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

SB 08/09/11 (x3)

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS23Crl  
08-09-12 (x3)

5.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/16

Job Completion



MF 08-09-16

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

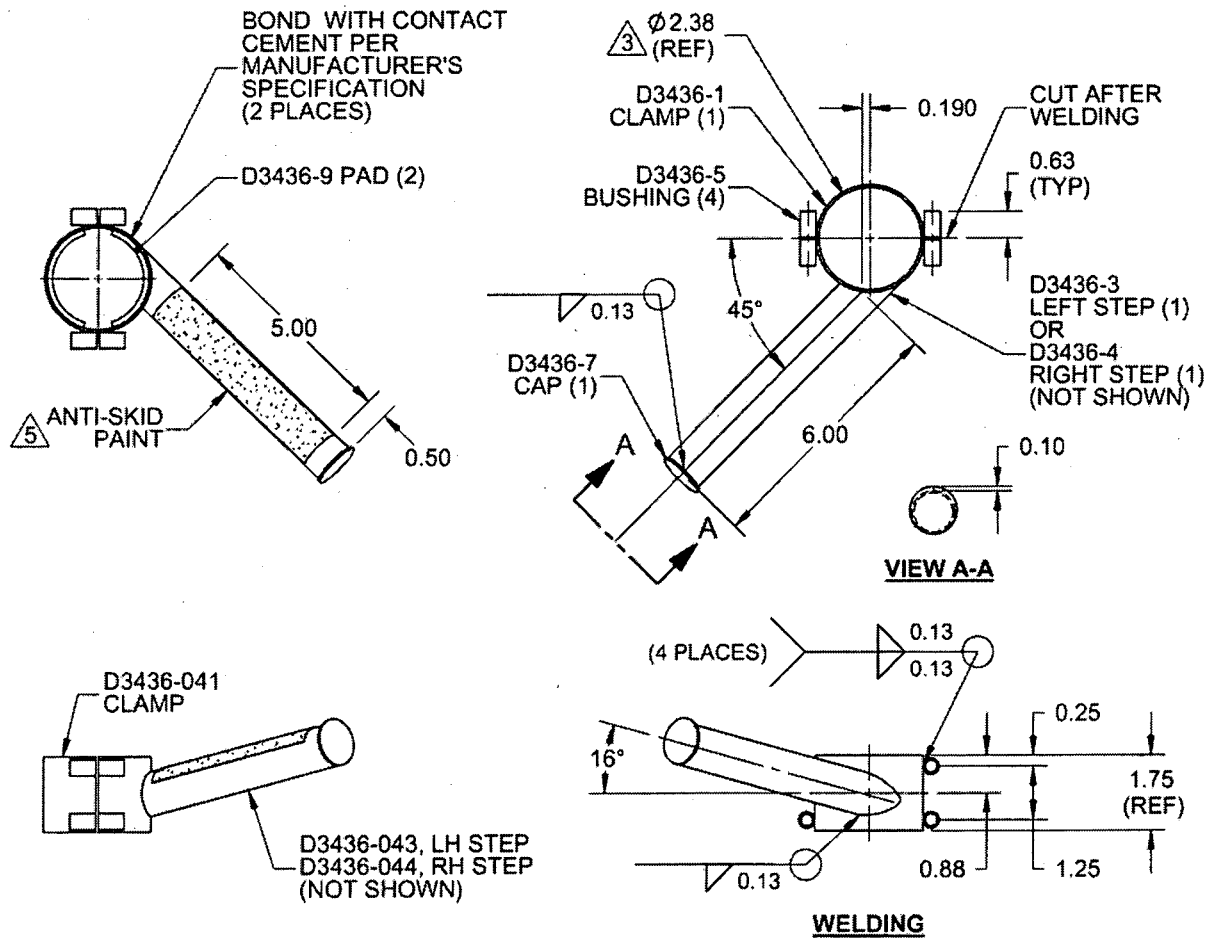
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART**

|                         |                |  |                        |
|-------------------------|----------------|--|------------------------|
| DESIGN<br>MB            | DRAWN BY<br>MB | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>#            | APPROVED<br>#  | DRAWING NO.<br><b>D3436</b>                              | REV. A<br>SHEET 1 OF 4 |
| DATE<br><b>05.04.28</b> |                | TITLE<br><b>MAINTENANCE STEP</b>                         | SCALE<br>1:4           |
| A                       | 05.04.28       | NEW ISSUE  |                        |

**NOTES:**

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

05.05.27

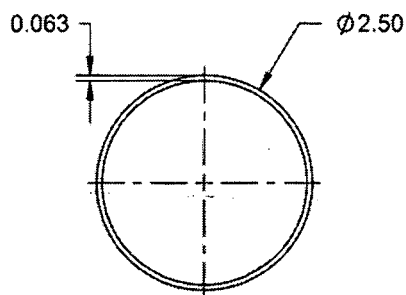
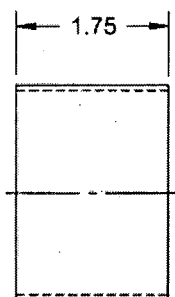
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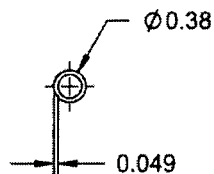
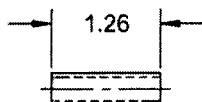


|                         |                                  |  |                        |
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| CHECKED<br>H            | APPROVED<br>H                    | DRAWING NO.<br><b>D3436</b>                              | REV. A<br>SHEET 2 OF 4 |
| DATE<br><b>05.04.28</b> | TITLE<br><b>MAINTENANCE STEP</b> |  | SCALE<br>1:2           |



#### **D3436-1 CLAMP**

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



#### **D3436-5 BUSHING**

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

**RELEASED**

05-05-27 H

#### **D3436-1/-5, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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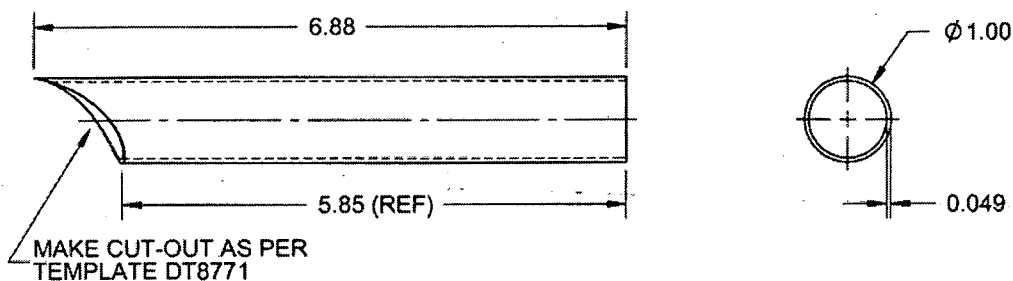
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WORK ORDER  
49013

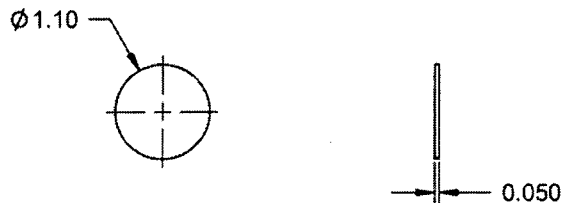
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|                               |                                |  |                        |
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| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3436</b>                              | REV. A<br>SHEET 3 OF 4 |
| DATE<br><b>05.04.28</b>       |                                | TITLE<br><b>MAINTENANCE STEP</b>                         | SCALE<br>1:2           |

**D3436-3 LEFT STEP**

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)

**D3436-7 CAP**

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

**RELEASED**05-05-27-*[Signature]***D3436-3/-7, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

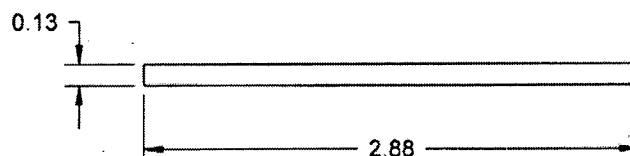
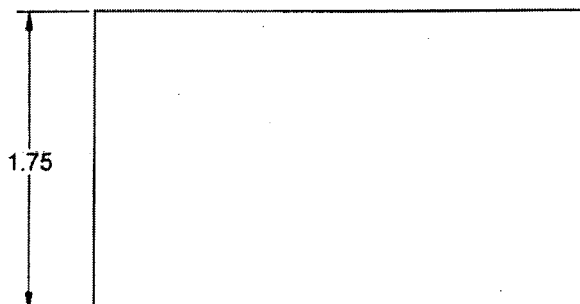
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| DATE<br>05.04.28 | TITLE<br>MAINTENANCE STEP |   | SCALE<br>1:1           |



RELEASED

05-05-27

**D3436-9 PAD**

**NOTES:**

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK  
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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